

Date: Friday, 09/05/2008 1:47:23 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : RH STEP ACTUATOR ASSEMBLY
Job Number : 39168	
Estimate Number : 12760	
P.O. Number :	Part Number : 41232 000 001 002
This Issue : 09/05/2008 S.O. No. :	Drawing Number : 41232-000-001 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : A
Previous Run : 35060	Material :
Written By :	Due Date : 30/05/2008 Qty: 2 Um: Each
Checked & Approved By : <u>JLD 08.5.09</u>	
Comment : Est Rev:A New Issue 07-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JLD 08.5.13



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP41232-000-001 CHG 002

S 08/05/13

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	AP0925ELBN	BARBED ELBOW
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

BARBED ELBOW

Batch:

M103727

AS 08/05/15 (X2)

4.0	AN960JD416	Washer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch:

M107321

AS 08/05/15 (X2)

5.0	MS21042L4	Nut
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch:

M106051

AS 08/05/15 (X2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH STEP ACTUATOR ASSEMBLY

Job Number: 39168

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN423A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bolt

Batch:

M103688

AS 08/05/15 (X2)

7.0

MS3548993

GROMMET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

GROMMET

Batch:

M106168

AS 08/05/15 (X2)

8.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

M107008

AS 08/05/15 (X2)

9.0

MS24665151

Cotter Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Cotter Pin

M14526

AS 08/05/15 (X2)

10.0

MS203923C21

Pin



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pin

M104156

AS 08/05/15 (X2)

11.0

R 3400

plastic tubing 1/4id x 3/8od-black



Comment: Qty.: 3.0500 f(s)/Unit Total: 6.1000 f(s)

plastic tubing 1/4id x 3/8od-black

Cut to 18" Long X2

Batch:

M104229

New Batch in comp.

AS 08/05/15 (X2)

12.0

41232 200 006 001

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Bracket

Batch:

M30505

AS 08/05/15 (X2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RH STEP ACTUATOR ASSEMBLY

Job Number: 39168

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

41232 200 005 001

Spacer (Step Actuator)



Comment: Qty.: 3.0000 Each(s)/Unit Total: 6.0000 Each(s)

Spacer (Step Actuator)

Batch: 30304

AS 08/05/15 (2)

14.0

41232 200 004 001

Reducer Tee Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Reducer Tee Assembly

Batch: 31779

AS 08/05/15 (2)

15.0

41232 200 003 001

Spring (Step Actuator)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Spring (Step Actuator)

Batch: 30941

AS 08/05/15 (2)

16.0

41232 200 001 002

Step Actuator RH Ass'y



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Step Actuator RH

Batch: 39175

AS 08/09/23 (2)

17.0

124K002 4CR 0545

Hose ass'y-Step Actuator



Comment: Qty.: 1.0000 Each(s)/Unit Total: 2.0000 Each(s)

Hose ass'y-Step Actuator

BATCH: M104042

AS 08/05/15 (2)

18.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/09/23 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP 41232-000-001-001

Location:

PPP Rev:

Rev B

AS 08/09/22 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Drawing Name: RH STEP ACTUATOR ASSEMBLY

Job Number: 39168

Part Number: 41232 000 001 002

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/23 JJ

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	1/14/04	INCRP. E.O.; CHG. P/N OF ITEM #17. MINOR CHANGE - FAR 21.95	1/14/04	1/14/04

A			1	1	17	PS4025E000DF540A	HOSE						
			1	1	16	AP0925ELBN	BARBED ELBOW	ARK-PLAS PRODUCTS, INC., FLIPPIN, ARKANSAS 72634					
			2	2	15	AN960JD416	WASHER						
			1	1	14	MS21042-L4	NUT						
			1	1	13	AN4-23A	BOLT						
		AR	AR	12		MIL-S-8802	SEALANT						
			1	1	11	MS35489-93	GROMMET						
			2	2	10	AN960JD416L	WASHER						
			1	1	9	MS24665-151	COTTER PIN						
			1	1	8	MS20392-3C21	PIN						
			2	2	7	R-3400 1/4 ID x 3/8 OD BLACK	PLASTIC TUBING	NORTON PERFORMANCE PLASTICS CORP., AKRON, OHIO 44309					
			1	1	6	41232-200-006-001	BRACKET	(ALT. P/N 412-050-026-101, BELL HELICOPTER)					
			3	3	5	41232-200-005-001	SPACER						
			1	1	4	41232-200-004-001	REDUCER TEE						
			1	1	3	41232-200-003-001	SPRING						
			1		2	41232-200-001-002	R/H ACTUATOR ASSY						
			1	1		41232-200-001-001	L/H ACTUATOR ASSY						
						-002	R/H INSTALLATION						
						-001	L/H INSTALLATION						
			-002	-001	FWD NO.	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
NO. REQ'D PER ASSY													
LIST OF MATERIAL													
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<div> <div> <div>UNLESS OTHERWISE SPECIFIED</div> <div> <p>X.2.1 X.1.2.03 X.001.2.010 ANGLES 2.1/2</p> </div> </div> <div> <div>DFTSMAN</div> <div> <p>D. NELSON D. MURPHY</p> </div> </div> <div> <div>CHECK</div> <div> <p>5/20/02 5/20/02</p> </div> </div> <div> <div>STRESS</div> <div> <p>PERL ENGR.</p> </div> </div> <div> <div>HEAT TREAT</div> <div> <p>FINISH</p> </div> </div> <div> <div>TITLE</div> <div> <p>STEP ACTUATOR INSTALLATION</p> </div> </div> <div> <div>DWG. NO.</div> <div> <p>41232-000-001</p> </div> </div> <div> <div>SCALE</div> <div> <p>C NONE</p> </div> </div> <div> <div>DWG. SIZE</div> <div> <p>C</p> </div> </div> <div> <div>SCALE</div> <div> <p>NONE</p> </div> </div> <div> <div>ERA AVIATION, Inc.</div> </div> <div> <div>DWG. NO.</div> <div> <p>41232-000-001</p> </div> </div> <div> <div>SHT</div> <div> <p>1 OF 2</p> </div> </div> <div> <div>REV.</div> <div> <p>A</p> </div> </div> </div>													

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 WORK ORDER
 NO. 391108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

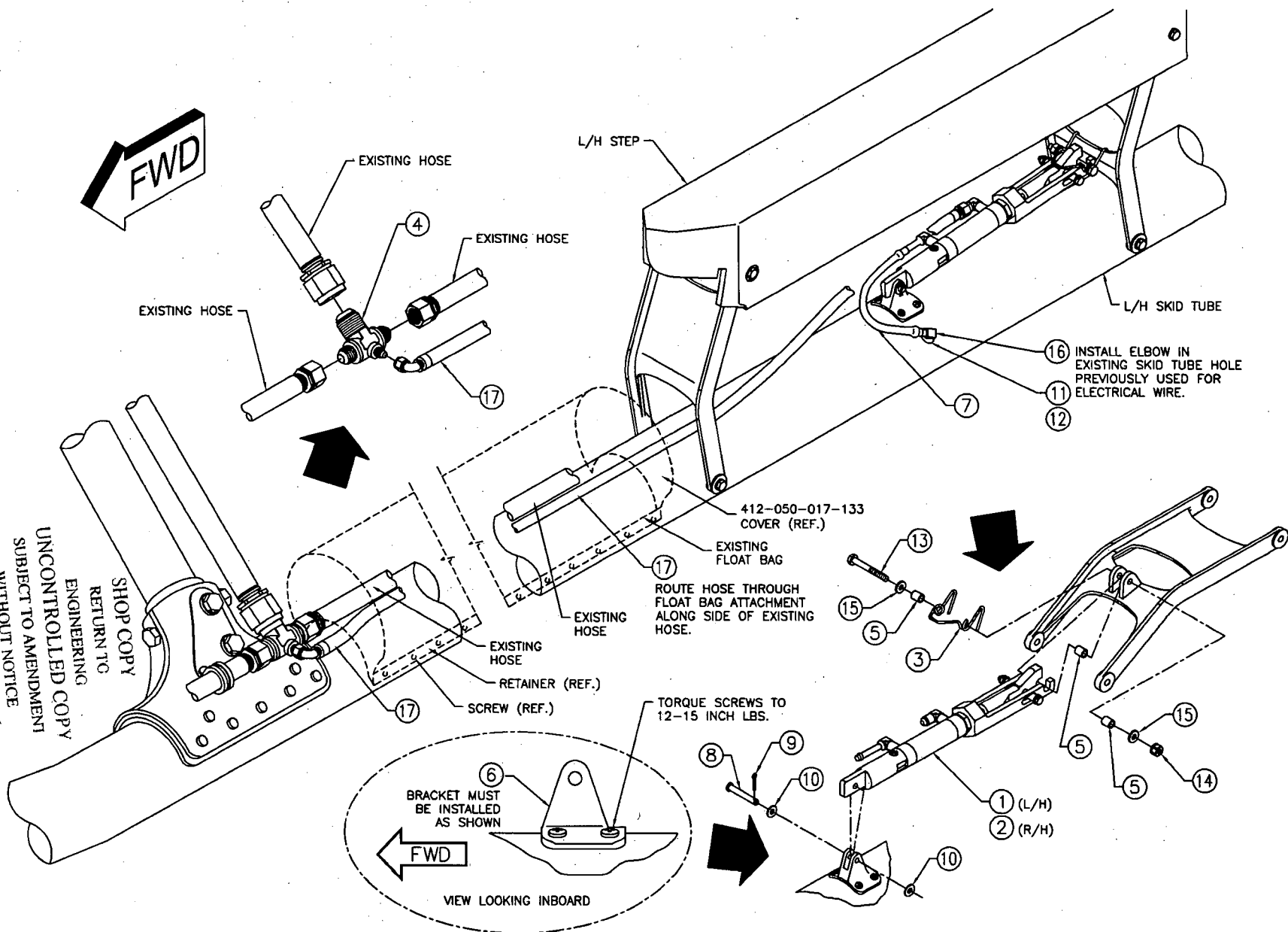
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO

WORK ORDER
51162



-001 L/H INSTALLATION (SHOWN)
-002 R/H INSTALLATION (OPPOSITE)

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STEP ACTUATOR INSTALLATION

SIZE
C

DRG. NO.
41232-000-001
SHT 2 OF 2

REV.
A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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